

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010152**Date Inspected:** 05-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

BK001-018

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as BK001-018-003, 004. The welder is identified as #220066 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-TC-U4c-F.

Segment 2AE/2BE

This QA Inspector observed ABF Personnel performing Ultrasonic Testing (UT) on the Edge Plate to Deck Plate CJP splice, bike path side using the D scan method.

Plate Yard

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## WELDING INSPECTION REPORT

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This QA Inspector selected Three (3) 460mm x 355mm plate check samples and assigned a QA Lot number to each of following sampled material:

Item 702: 75mm A709M-345F2-X-Z, HT# 09304163N3, Lot# B222-079-09

Item 703: 75mm A709M-345F2-X-Z, HT# 09401355N2, Lot# B222-078-09

Item 704: 35mm A709M-345T2-X, HT# 07302644NO, Lot# B222-080-09

Samples were marked with Lot number, Item number, material thickness, date and direction of rolling. Samples will be shipped to an Independent Testing lab.

ZPMC Quality Control (QC) Inspector is identified as Song Hui. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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